Work Orde Thursday, Septem							•					Page 1
Revision ID: Item Name:	D3535-35 Wearshoe D/30/2010 10/8/2010	Start Qty: 8.00 Req'd Qty: 8.00		Accept	Cust Item Customer:	ID:			Setup	Start		
	Process Pla	n:	Date: 10-9-3	Tooling: SPC (Y/N):		ate:]	Run	Start Stop		1111 111 1111 1111 1115 115 1151 1551
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr						~~	~-			Stamp
D3535	Rev	В										
Waterjet FLOW CNC Waterjet 304.040		FLOW WATER JET Memo 1-Cut as p Deburr if t	er Dwg D3535 □Dwg Rev necessary	0.00 :□Prog Rev:	₿ □2-		•	Ħ3 ·	10-10	s-5	()	3)
QC Quality Control		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				HB 10	7- <u>ر</u>)- 5		Pro-
120 QC Quality Control		QC8- Inspect parts - se	cond check	0.00	110106			412		<u>~</u>	/·	

W/O:		WORK ORDER CHANGES							
DATE	STEP PROCEDURE CHANGE By		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No: <u>D3535-35</u>	PAR #:الم.	Fault Category	: In Falo.	_ NCR: Yes No	DQA:	Date:	10.10.26
Resolution: _	SCRAP	Disposition:	Scrap	QA: N/C Closed			

NCR:67	2461	W	ORK OR	DER NON-CONFORMANCE	E (NCR)			
DATE	OTED	Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
iolada	# 190	Found at inspection that cat, it part has I .300 x .300 hole cut wany At Part make Domin	JUSIUAZ	10 KADIACO DI	B .10-10-6	5/10/10/	105/14/2.	Sieles
lolide	申	DC Part move l'After dumin water setting process	psiwn					S 10/10/06
				-				

Work Order ID 62461	Work	Order	ID	6246 1
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Thursday, September 30, 2010 12:43:27 PM



Page 2

Item ID:

D3535-35

Accept



Setup Start

Stop

Stop



Revision ID:

Start Date:

Item Name: Wearshoe

Required Date: 10/8/2010

QC:

9/30/2010

Start Qty: 8.00

Req'd Qty: 8.00

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____

Date:_____

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Sequence ID/ Work Center ID

130

Brake NC

Operation Description

NC BRAKE

Set Up/ **Run Hours**

0.00

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Brake NC

1-Deburr if necessary □2-Form on Brake as per Dwg D3535 using Jigs

DT8261and DT8326. □3-Identify as D3535-35.

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

_DOVEN TEMPERATURE:

W/O:			M	ORK ORDER CHANG	GES				t *
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Part No		PAR #:							
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NCR:			WORK OR	DER NON-CONFORM	ANCE (NO	CR)			, , , , , , , , , , , , , , , , , , , ,
DATE	STEP	Description of NC		······································	ction B	v	erification	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		Section C	Chief Eng	QC Inspector
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Work Order ID 62461

Thursday, September 30, 2010 12:43:27 PM



Page 3

Item ID:

D3535-35



Setup Start

Stop



Revision ID:

Item Name: Wearshoe

Required Date: 10/8/2010

Start Date:

9/30/2010

Start Qty: 8.00 Req'd Qty: 8.00

Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan:

Date: ____ Tooling:

Accept

Date:

Run Start



Date: SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

F180.00 fl 10-10-121.

Tool ID

Tool # Plan Qty Code

Accept Reject Qty

Reject Number

Insp. Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/15 XX) MT 10-10-14

W/O:			W	ORK ORDER CHA	ANGES					P 4
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	In lates	Corrective Action	Section B	Ciam 9	Verific		Approval	Approval
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Picklist Print

Thursday, September 30, 2010 12:43:31 PM

Work Order ID: 62461

D3535-35 Parent Item:

Parent Item Name: Wearshoe



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115440

Start Date: 9/30/2010

Required Date: 10/8/2010

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA	HIII HI II III III	Purchased	No			100	sf	122.8987	0.8022	6.755368	B(0-1	٥-5	
				Location		Loc C		Loc Code				\searrow	
				MAT	114574	100.1 10.6						(13)	
					115762		89.5			115762			
				MAT20		22.7	465						
					112885	2.7	475						

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DART AEROSPACE LTD	Work Order:	1,4261
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

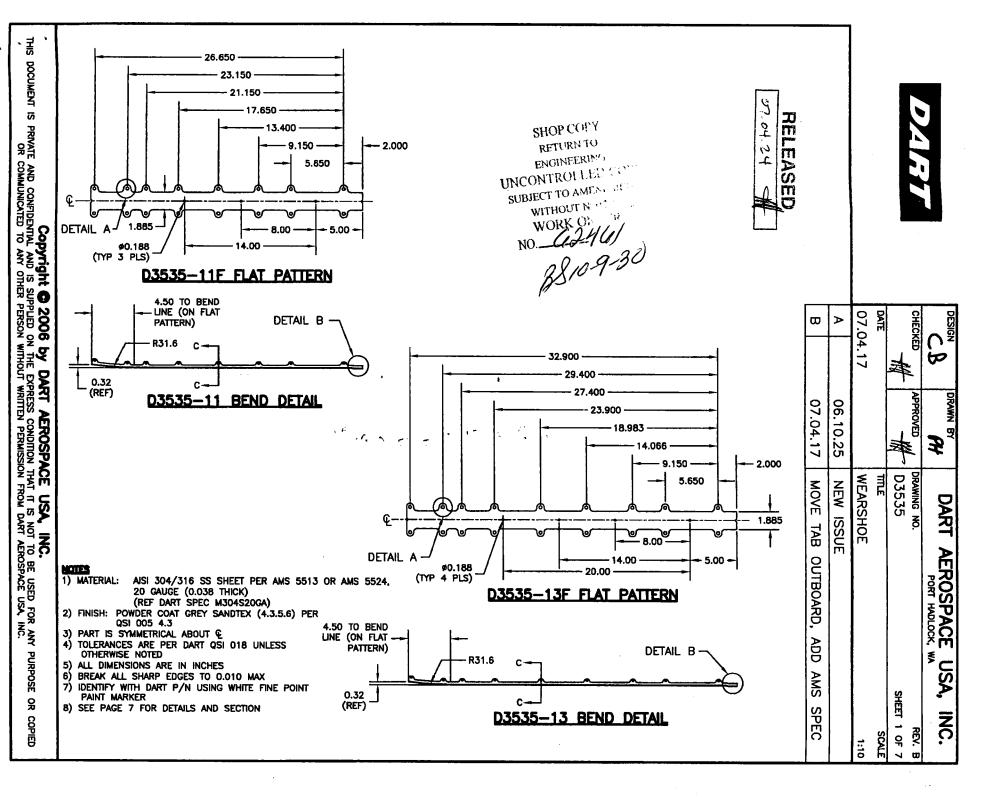
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6.75	+/-0.030	6,749	×		V	
Ø0.188	+0.005/-0.001	188	*		V	
23.250	+/-0.010	23.250	4		T 1801	
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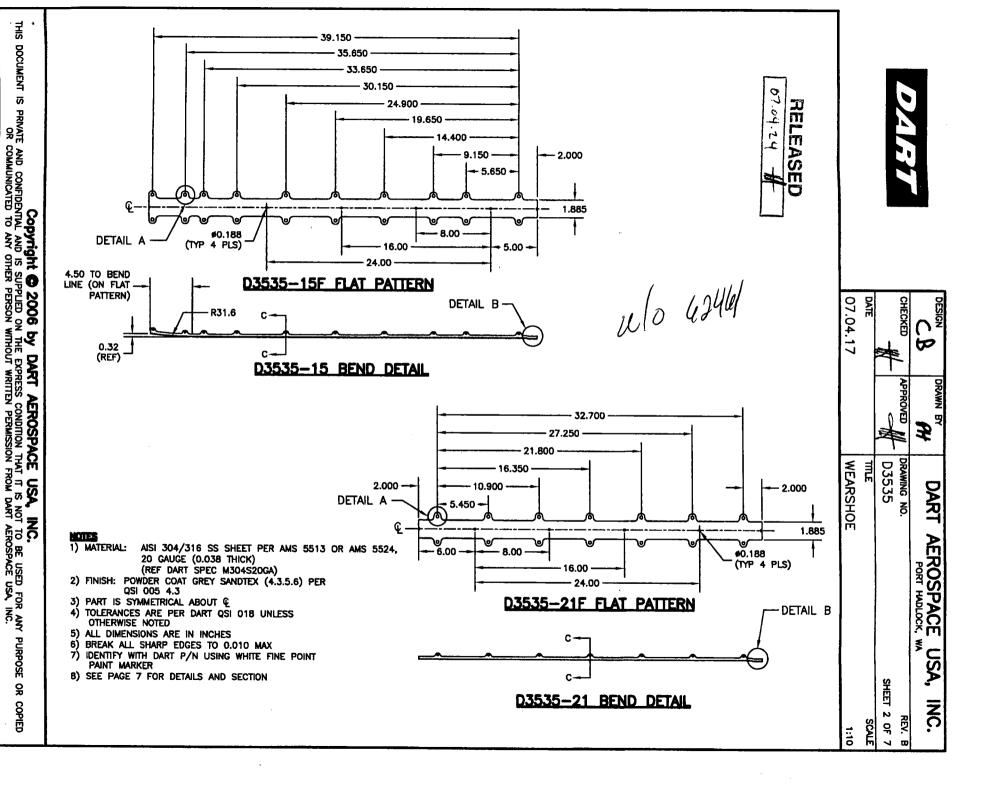
Measured by:	B	Audited by:	2	Prototype Approval:	N/A
Date:	10-10-5	Date:	10/10/06	Date:	N/A

[Rev	Date	Change	Revised by	Approved
	A	07.05.10	New Issue	KJ/JLM 🛠	E

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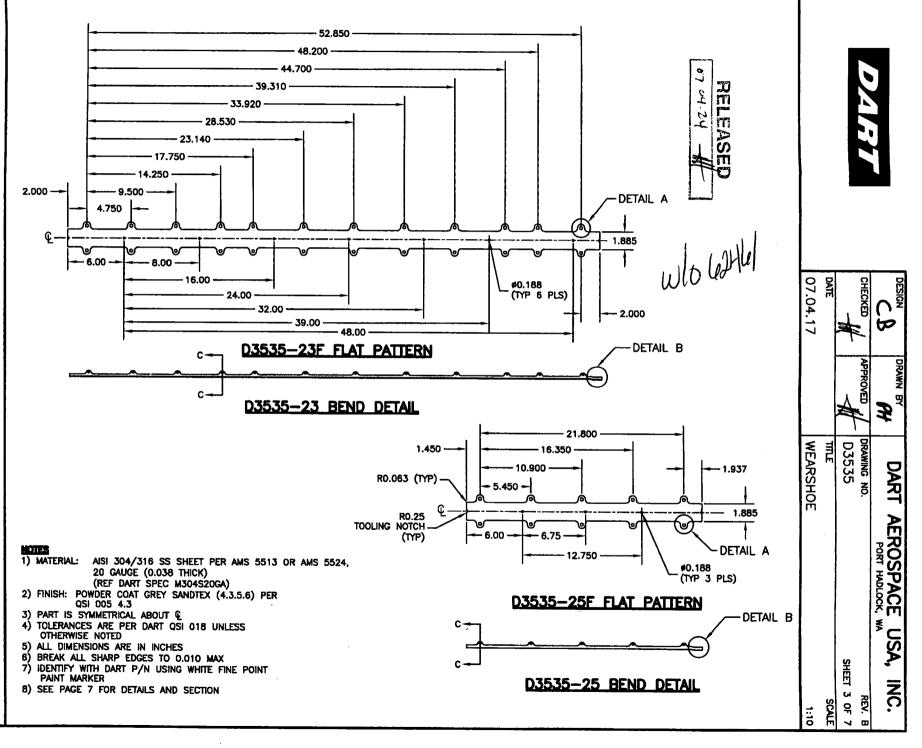


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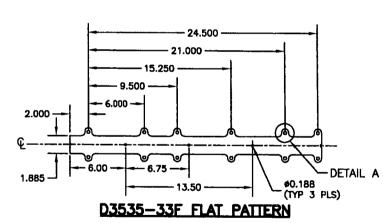
RELEASES

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D3535-31 BEND DETAIL

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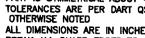


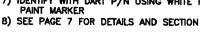
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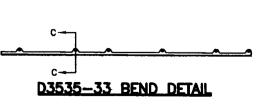
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER

- QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES TO 0.010 MAX IDENTIFY WITH DART P/N USING WHITE FINE POINT 7)

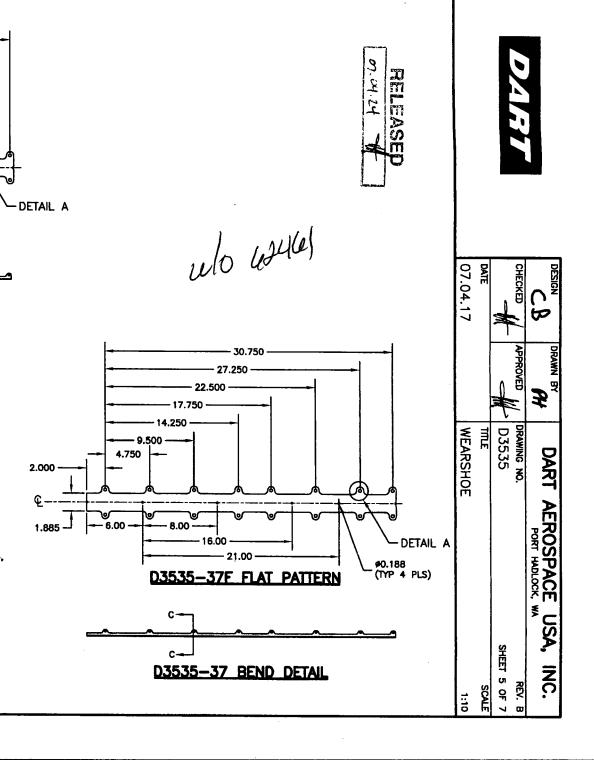






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W/O:			W	ORK ORDER CHANG	ES				
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4.750 2.000 1.885 D3535-35F FLAT PATTERN

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PURPOSE

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COPIED

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)

23.250 19.750

#0.188

-35 BEND DETAIL

(TYP 2 PLS)

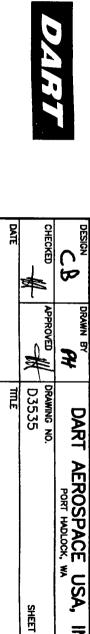
17.750

14.250 9.500

- (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
- QSI 005 4.3

 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

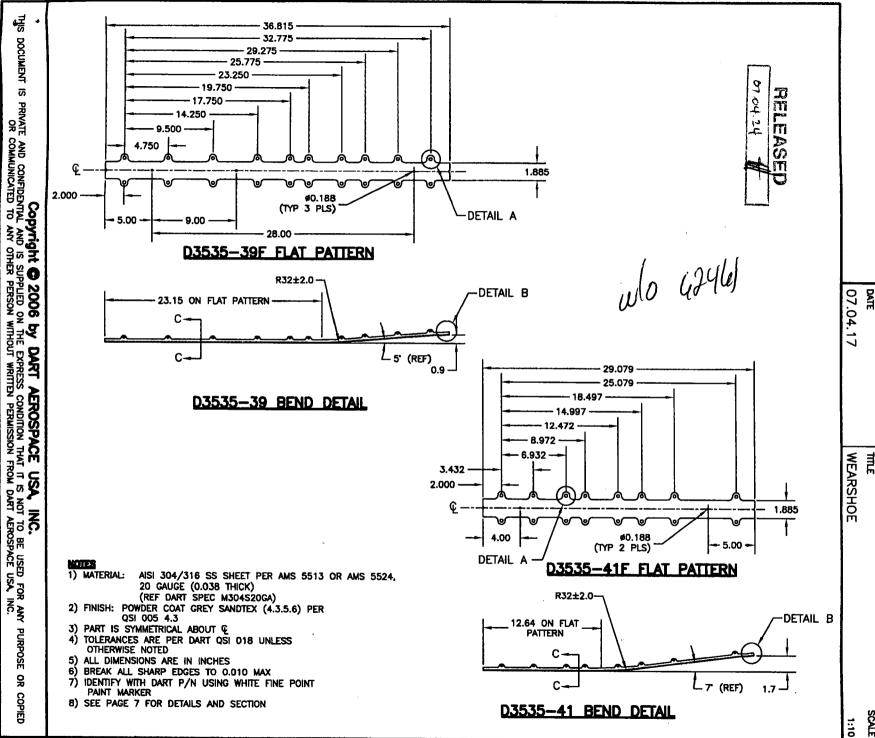
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PURPOSE

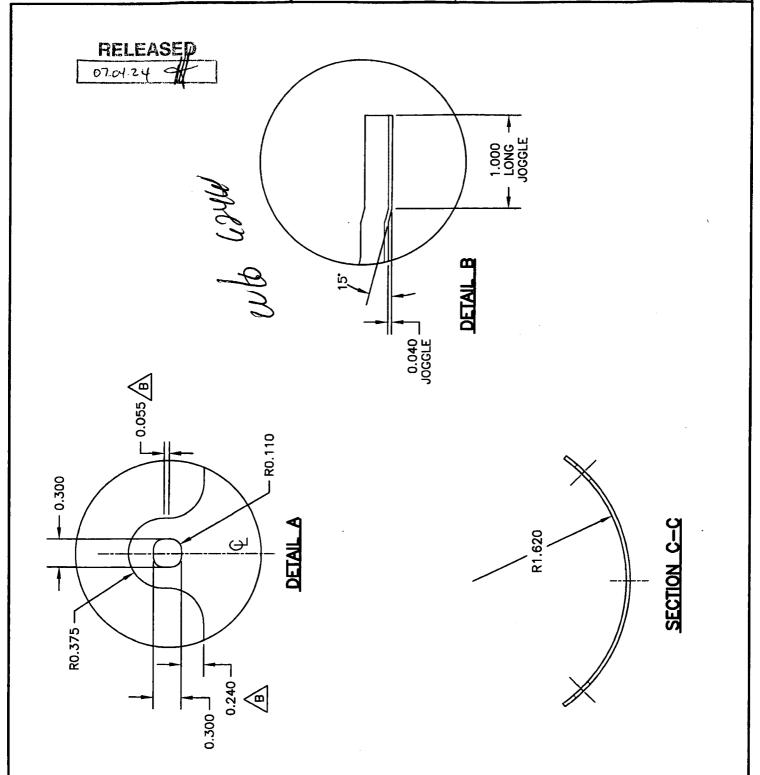
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